Work Orde Friday, January):08:54 AM		*110	604*						Page 1
Revision ID:	D3447-9 Swing Arm	D 3 4 4	7-9 604	Accept	*N900	040	100)* s	Setup Star Stop	171	S1* S2*
Start Date: Required Date: Reference:	1/3/2014 1/31/2014	Start Qty: 24.00 Req'd Qty: 24.00		16	Cust Item I Customer:	D:					,
Approvals:	Process Pla	an: MF	Date: (4-01-03) Date:	Tooling: SPC (Y/N):	,	nte:		F	Run Star Stop	/ / / / / / / / / / / / / / / / / / /	R1* R2*
Sequence ID/ Work Center IE)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	vision Nbr									-
D3447	Rev	v A									
*100 *100* Bandsaw Jeaspa Bandsaw		BAND SAW Memo Cut blanks	: 1.500" x 1.500" x 8.400" l	0.00 0.00 ong	me 14/01/6	1		16	_#		
110 *110* HAAS 1 HAAS CNC vertical	machine #1	HAAS CNC VERTICA Memo Machine a Rev A	AL MACHINING #1 s per Folio FA544 and Dwg Folio Rev <u>A</u> Deburr	0.00 0.00 B67-43001Identify as D3	447-9Dwg	1 05 07		_15	<u> </u>		<u> </u>
120 *1 7 ^* QC Quality Control		QC2- Inspect parts off Memo	machine FAI/FAIB	0.00 OR	14/01/ b-14/01/	05		15	1		

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DQA:	Stol		14/2	•	WORK ORDER NON	-cc	ONFO	RMANCE / UPDA		ork Order up	date only	DART AEROSPACE
Mark Ordon	7 11 06	,0Y			DISPOSITION			-	AGAINST DE	PARTMENT	PROCESS	,
	. D 344	7-9	•		Rework Scrap Use-as-is Suspected Unapproved			Machining S noforming	rosstube small Fab Finishing omposite		Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
Root				Descr	iption of work order update	Γi	nitial	Action		Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved	14.01.07	110	1		38 radius not full radiend end opposite to fark end call geometry incorrect.	14	A.P. A.P.	Blend radius to sharp endges govers. Non- part : acceptate re-work return factor of blad notion of blad hit.	cond -cirwathy ble to in to aspection of part I limit de fold	A.R. 14-01-07 A.R. 14-01-07 A.R. 14-01-07 14-01-07	DAS 27 9-89	DAS 27 9-89
						FAI	ULT CAT	EGORY				
Landing	Gear Bending Centre No Cracks Crimp/Kir Cuffs Crushing Heat Trea Inspection Marks/Ch Turning S	nk/Ripple at n Strip in natter	/Wave Tube		General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish	-	Grain Hardwa Inspect Instruct Misalia Mislaba Misreaa Off-set	ion Incomplete/Unqual ions Incomplete/Uncle ned/off center led	ear	Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	tolerance ci ssing Vrong	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other
I		ist in Tuk	20		Fit/Function		Out of	Seguence				

W	ork	Oro	ler	ID	110	604
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110604

Page 2

Friday, January	03, 2014 10):08:54 AM			/						
Item ID: Revision ID: Item Name:	D3447-9 Swing Arm			Accept	*N900	040	100)* s	Setup Star Stoj	· IVI.	S1*
Start Date: Required Date: Reference:	1/3/2014	Start Qty: 24.00 Req'd Qty: 24.00	*24* *24*		Cust Item I Customer:	D:			·	' 'IVI	S2*
Approvals:	Process Pla	an:	Date:	Tooling: SPC (Y/N):		nte:		R	tun Star Stop	^ \	R1* R2*
Sequence ID/ Work Center I 130 *1 20* QC Quality Control	D	Operation Description QC8- Inspect parts - seco	nd check	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *1 \(\tau\) HandFinish Hand Finishing		Chemical Conversion Co	at per QSI005 4.1	0.00				-15	HE	15/1	-13
150 *1 \^ Powdercoat Powder Coating		TEME: 3	holes 🏂 🍘r Dwg D3447 p	0.00 0.00 prior to paintingSTART TEMPERATURE:				15	ф <i>р</i>	4 <u>-1-3</u> 8	9

DQA:		Date:										TQAC ^D
	ļ				WORK ORDER NON-	-CC	NFO	RMANCE / UPDATE				AEROSPACE
QA Closed:		Date:							W	ork Order up	date only	
					DISPOSITION			AGAINST	DE	PARTMENT	/PROCESS	
Work Order:				_	0			Claid tuba Creestuba		1	Water Jet] Engineering
Part No.	1				Rework Scrap			Skid-tube Crosstube Machining Small Fab	_	Pro	d. Eng. Coor.	Engineering Quality
1 41 (140.					Use-as-is			noforming Finishing	_	4	re/Packaging	Other
NCR No.					Suspected Unapproved		111011	Large Fab Composite	_		Supplier	
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Root				Desci	ription of work order update	ı	nitial	Action		Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
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Equip/Tooling]					İ						
Handling/Pre											:	
Material					·							
Operator	4	i										
Offset/Setup	1											
Process		!										
Supplier	4											
Training	· ·											
Transport	4											
Unapproved	<u> </u>					<u> </u>						
						FA	ULT CA	TEGORY				
Landing	7				General		le-1:- //		_]		7p/r
<u> </u>	Bending			\vdash	Bend BOM/Boute	┝	1	Program	┡	Outside Dim	<u> </u>	Pressure/Forced
[Centre No	ot Concer	ntric	-	BOM/Route	_	Grain		<u> </u>	Over/Under		Set-up Temperature/Cure
-	Cracks	ale/Dimmlo	Maria	ļ	Broken/Damage/Defect	-	Hardw		-	┥	<u> </u>	Weld
-	Crimp/Kir	ik/kippie	y wave	\vdash	Burrs	\vdash	1 '	tion Incomplete/Unqualified tions Incomplete/Unclear	\vdash	Part Lost/Mi Part Moved		Wrong Stock Pulled
-	Cuffs Crushing			\vdash	Contamination Countersink	\vdash	4	gned/off center	\vdash	Positioned V		
<u> </u>	Heat Trea	. +		 	Cut Too Short	H	Mislab	· ·	-	Power Loss/		Other
-	Inspection		Tuhe	-	Drawing	\vdash	Misrea		<u></u>	J. 044Ci 2033/		104101
	Marks/Ch		·ubc		Drill Holes	\vdash	Off-set					
	Turning S				Finish	\vdash	4	Calibration				
1 		ist in Tut			Fit/Function	\vdash	4	Sequence				·····

Work Ord Friday, January				*1100	304*							Page 3
Item ID: Revision ID: Item Name: Start Date: Required Date: Reference:	D3447-9 Swing Arm 1/3/2014 1/31/2014	Start Qty: 24.00 Req'd Qty: 24.00	*24* *24*	Accept	*N900 Cust Item I Customer:		100			Stop		S1* S2*
Approvals:	Process Pla	n:	Date:	Tooling: SPC (Y/N):		ate:		R		Start Stop	*N *N	R1*
Sequence ID/ Work Center II 160 *1 60* QC Quality Control	D	Operation Description QC3- Inspect Part Finish Memo		Set Up/DAS Run Hours 0.00 4-89 0.00 14 1 30	Tool ID	Tool#	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp
170 *170* Packaging Packaging		Identify as per dwg & Stoo Memo	ck Location: <u>Me</u> ZZ	0.00				_15>	DAS 28 9-85	5 3 9	14-0	(<u>-3</u>)

QC21- Final Inspection - Work Order Release

0.00

1 20

Memo

0.00

Quality Control

MW 14-02-03

180

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AEROSPACE		RMANCE / UPDATE	CONFO	WORK ORDER NON-			,		
e only	ork Order update only	W				Date:	1		QA Closed:
OCESS	PARTMENT/PROCESS	AGAINST DE		DISPOSITION			!	er:	Work Ord
Water Jet Engineering	Water Je	Skid-tube Crosstube		Rework			<u> </u>	-	
	Prod. Eng. Coor	Machining Small Fab		Scrap				No.	Part I
ackaging Other Other	Rec/Store/Packaging	noforming Finishing	Ther	Use-as-is				-	
Supplier	Supplie	Large Fab Composite		Suspected Unapproved			· · · · · · · · · · · · · · · · · · ·	No	NCR
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erification QC Inspector	I - I			· ·	1	itep C	Date		
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ons Pressure/Forced Set-up Temperature/Cu Weld Wrong Stock Pulling	Outside Dimensions Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Positioned Wrong Power Loss/Surge	TEGORY Program are tion Incomplete/Unqualified tions Incomplete/Unclear gned/off center eled d	Grain Hardw Inspec Instruc Misali Mislab Misrea Off-set	General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish Fit/Function	c	Concentri Ripple/W trip in Tu ter uence		ing G	Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport

Friday, January 03, 2014 10:08:53 AM

Page 1

Work Order ID:

110604

Parent Item:

D3447-9

Parent Item Name:

Swing Arm

Start Date: 1/3/2014

Required Date: 1/31/2014

Start Qty: 24.00

Loc Code

Required Qty: 24.00

Comments:

IPP A05.08.26New issueKJ/JLM

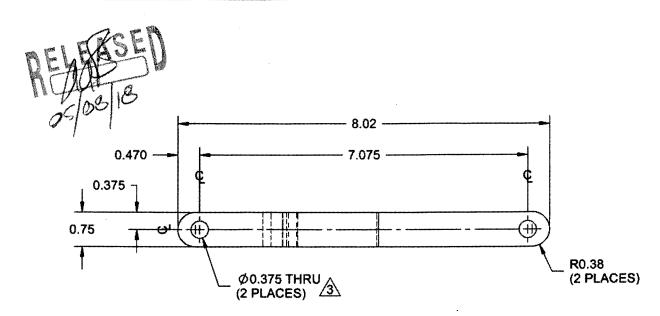
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M7075T6B1.500X1.500		Purchased	No			100	f	18.5000	0.7	18			

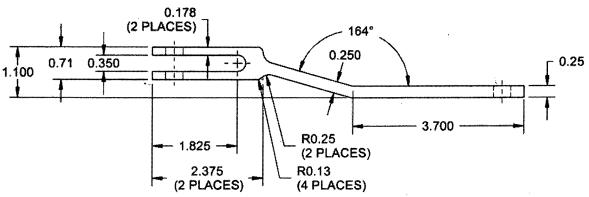
Location Loc Oty MAT008 18.5 123610 1 125363 0.5 m126705 1 → m127420 16

16 on 14/01/05

DQA:		<u>:</u>	Date:						_				TRAGE
						WORK ORDER NON-	-CC	ONFO	RMANCE / UP				AEROSPACE
QA Closed:			Date:				-			W	ork Order up	date only	
Work Orde	or.					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
Work Orac						Rework	1		Skid-tube	Crosstube	٦	Water Jet	Engineering
Part N	lo.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	•				_	Use-as-is	1		noforming	Finishing		re/Packaging	Other
NCR N	lo.					Suspected Unapproved			Large Fab	Composite		Supplier	
Root					Desci	ription of work order update		nitial	Acti	on	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption	Date	Verification	QC Inspector
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		Centre No	ot Concer	ntric	\perp	BOM/Route	<u> </u>	Grain		_ , · • -	Over/Under	<u> </u>	Set-up
		Cracks			-	Broken/Damage/Defect	\vdash	Hardwa		<u> </u>	Part Incorre	⊢	Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs	<u>_</u>	1 '	ion Incomplete/Un	· —	Part Lost/M	issing	Weld
	<u> </u>	Cuffs				Contamination		4	tions Incomplete/U	nclear	Part Moved	L	Wrong Stock Pulled
		Crushing			<u> </u>	Countersink		4	gned/off center	<u> </u>	Positioned V		- 7
	_	Heat Trea				Cut Too Short		Mislab		L	Power Loss/	Surge	Other
	-	Inspectio	-	Tube		Drawing		Misrea					
	$ldsymbol{ldsymbol{eta}}$	Marks/Ch			\vdash	Drill Holes	_	Off-set					
	$ldsymbol{ld}}}}}}$	Turning S			\vdash	Finish	\vdash	4	Calibration				
1	1	Wave/Tw	ist in Tub	e		Fit/Function		Out of	Sequence				







* 1106 cs **D3447-9 SWING ARM** SUPERSEDES PREMIER P/N B67-43001-263

NOTES:

1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T652) ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC. M6061T6B) 2) CHEMICAL CONVERSION COAT PART QSI 005 4.1

COVER INSIDE HOLES PRIOR PAINTING

4) FINISH: POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 6) ALL DIMENSIONS ARE IN INCHES

7) BREAK ALL SHARP EDGES 0.005 TO 0.010

DQA:			. Date:										DART
QA Closed:			Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UPDAT		ork Order up	date only	AEROSPACE
Q (Closea.			Dute.										
Work Orde	er:					DISPOSITION			AG	GAINST DEI	PARTMENT/	PROCESS	
	•					Rework]		Skid-tube Cro	osstube		Water Jet	Engineering
Part N	lo.					Scrap			Machining Sm	nall Fab	Pro	d. Eng. Coor.	Quality
	-					Use-as-is		Thern	~ Ш	inishing	Rec/Stor	e/Packaging	Other
NCR N	١o.					Suspected Unapproved			Large Fab Com	nposite		Supplier	
D					D		Н	امندند	Action	···	Cian P	-	
Root	İ	Data	Cton	O+1/	Desc	ription of work order update or non-conformance	l	nitial ief Eng	Description	,	Sign & Date	Verification	QC Inspector
Cause **	\dashv	Date	Step	Qty		or non-comormance	Cil	nei Eng	Description		Date	vermeation	QC IIIspector
Design													
Doc/Data Equip/Tooling	-									İ			
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Operator									1		,		
Offset/Setup							İ						ļ
Process													
Supplier	П			ļ								`	
Training													
Transport													
Unapproved													
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Landi	ng (Gear				General	_				1	r	
		Bending			-	Bend .	<u> </u>	1	Program		Outside Dim	<u> </u>	Pressure/Forced
	_	4	ot Concer	ntric	<u> </u>	BOM/Route	<u></u>	Grain			Over/Under		Set-up
		Cracks			<u> </u>	Broken/Damage/Defect	_	Hardwa			Part Incorred	<u>-</u>	Temperature/Cure
	<u> </u>	Crimp/Ki	nk/Ripple	/Wave	<u> </u>	Burrs	-	1	ion Incomplete/Unqualif		Part Lost/Mi	ssing	Weld Wrong Stock Pulled
	<u> </u>	Cuffs			-	Contamination	\vdash	-	tions Incomplete/Unclea gned/off center		Part Moved Positioned V	L Vrong	wrong Stock Pulled
		Crushing			\vdash	Countersink Cut Too Short	\vdash	Mislabe			Positioned v	· -	Other
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	\vdash	Marks/Cl		iube	\vdash	Drill Holes	-	Off-set					
	-	Turning S			\vdash	Finish		┥	Calibration			· · · · · · · · · · · · · · · · · · ·	
	\vdash	Wave/Tu			-	Fit/Function	-	-	Seguence			·	

DART AEROSPACE LTD	Work Order: /	10604
Description: Swing Arm	Part Number:	D3447-9
Inspection Dwg: D3447 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototype
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Drawing	Tolerance	Actual	Accent	Reject	Method of	Comments		
Dimension	loierance	Dimension	Accept	Reject	Inspection			
8.02	+/-0.030	8.011	, —		4-6-	31006		
7.075	+/-0.005	7.074	•		11			
R0.38	+/-0.030	R375	_		R-6			
Ø0.375	+0.006/-0.001	Ø.375			Ven	ML-Olo		
0.75	+/-0.030	.747			31	,		
0.375	+/-0.005	.374			"			
0.470	+/-0.005	.467			''			
1.100	+/-0.010	1.104			10			
0.71	+/-0.030	.706			71			
0.178	+/-0.010	.177			,,			
1.825	+/-0.010	1.825			11			
2.375	+/-0.010	2.375			1,			
R0.25	+/-0.030	R.250	_		R-C			
R0.13	+/-0.030	R.125			11			
3.700	+/-0.010	3.700			Vem	11-06		
0.25	+/-0.030	.257			,*			
· ·								

Measured by:	and	Audited by:	FA	Prototype Approval:	N/A
Date:	14/01/05	Date:	14/01/09.	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	08.07.24	New Issue	KJ/DD	77

DQA: Date:							•		TRACT				
			WORK ORDER NON-CONFORMANCE / UPDATE										
QA Closed: Date:						Work Order update only							
Work Order:			DISPOSITION		AGAINS	AGAINST DEPARTMENT/PROCESS							
Part No				Rework Scrap Use-as-is Suspected Unapproved		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite		b	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier		Engineering Quality Other		
Root					Desci	ription of work order update	ı	nitial	Action		Sign &	,	
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved					C _O							•	
							FAI	ULT CA	TEGORY				
Landir	Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube Marks/Chatter Turning Sequence				General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspect Instruct Misalia Mislaba Misrea Off-set	tion Incomplete/Unqualified tions Incomplete/Unclear gned/off center eled d		Outside Dim Over/Under Part Incorre Part Lost/M Part Moved Positioned V Power Loss/	tolerance ct issing Wrong	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other	
1	Wave/Twist in Tube			10		Fit/Function		Out of	Sequence				